

Date: Wednesday, 18/02/2009 9:29:10 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 45847
 Estimate Number : 12615
 P.O. Number :
 This Issue : 18/02/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : 18/02/2009 Type : MACHINED PARTS
 Previous Run : 44196

Drawing Name : BEARPAW KIT (19"X24")

Part Number : D350578011
 Drawing Number : D2432 REV F3
 Project Number : N/A
 Drawing Revision : F3
 Material :
 Due Date : 27/02/2009

Qty: 8 Um: Each

Written By :
 Checked & Approved By : JLD 09.02.18

Comment :
 Est Rev:A New Issue 07-01-02 JLM
 Est Rev:B 08-01-09 Added Step 2 JLM Verified
 By:EC
 Est Rev:C 08-10-15 New Manufacturing Method JLM
 Verified By:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D350-578-011 CHG005

2.0 MFG ENGINEERING

MFG ENGINEERING



Comment: MFG ENGINEERING

Program Batch Number

3.0 MUHMWB10

UHMW 1" Black



Comment: Qty.: 3.4088 sf(s)/Unit Total : 34.0883 sf(s) : 27.2704 ~~34.0883~~ (not enough mat.)

Material: Black UHMW 1"

(MUHMWB10)

Batch: 110721

09.02.25

⑧

4.0 WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

Cut Blank as per D2432 File

09.02.25

⑧

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 18/02/2009 9:29:11 AM
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Seq. #:

Machine Or Operation:

Description :

5.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Note:(2) bearpaws for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2432 Identify as D2432F

3-Deburr

J.L./JA 09/02/25

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L./JA 09/02/25

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JS 09/02/26

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

9.0

D2182B

Rubber Cushion



Comment: Qty.: 2.5000 f(s)/Unit Total: 25.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2182B050 Rubber Cushion

measured 8 1/2/27 x 8 kits

42737

JS 09/02/27 x 8

10.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total: 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2274 Radius Block

2 D2432F(ref only) Bearpaw

ap

44547

JS 09/02/27 x 8

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2438

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total: ~~60.0000~~ Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2438 Clamp 43840

12.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total: ~~120.0000~~ Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2529 Washer 1345388

13.0

AN417A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total: ~~120.0000~~ Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-17A Bolt M109061

14.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total: ~~240.0000~~ Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

24 AN960JD416 Washer M110523

15.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: ~~120.0000~~ Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4 Nut (or -4) M1109282

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Signature 09/02/27 18

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-578-011

Location: _____

Rev A

Signature 09/02/27 18

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/02 *Signature*

Job Completion



Signature 09.03.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: H5047
Description: Bearpaw		Part Number: D2432
Inspection Dwg: D2432 Rev: F3		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.05348	✓			
B	5.500	+/-0.030	5.500	✓			
C	0.200	+/-0.030	0.200	✓			
D	0.25 x 45°	+/-0.030	0.248x45°	✓			
E	R0.250	+/-0.030	R0.250	✓			
F	0.250	+/-0.010	0.249	✓			
G	0.625	+/-0.030	0.626	✓			
H	0.375	+/-0.010	0.375	✓			
I	0.950	+0.030/0.010	0.953	✓			
J	19.000	+/-0.030	19.000	✓			
K	3.14	+/-0.030	3.147	✓			
L	3.28	+/-0.030	3.291	✓			
M	Ø0.260	+0.005/-0.000	Ø0.260	✓			
N	Ø0.93	+/-0.030	Ø0.927	✓			
O	0.30	+0.030/-0.000	0.310	✓			
P	23.750	+/-0.030	23.750	✓			
Q	7.375	+/-0.030	7.375	✓			
R	4.250	+/-0.010	4.250	✓			
S	2.000	+/-0.030	2.000	✓			
T	9.000	+/-0.010	9.000	✓			
U	9.000	+/-0.010	9.000	✓			
V	0.375	+/-0.010	0.380	✓			

Measured by: H.A	Audited by: JS	Prototype Approval: N/A
Date: 09/02/25	Date: 09/02/26	Date:

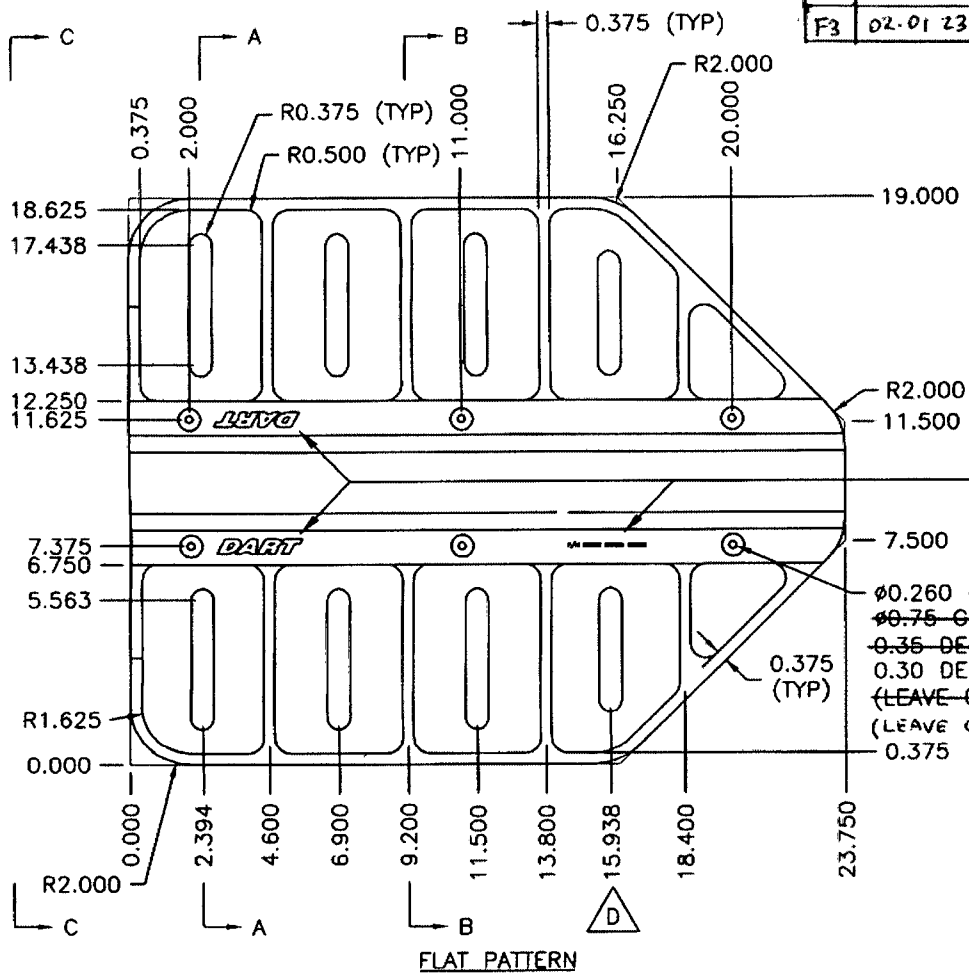
Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015	KJ/RF

ALL INFORMATION CONTAINED
HEREIN IS UNCLASSIFIED
DATE 04-05-2010 BY 60322
UCBAW

RELEASED
93-06-17 KES

93.06.17 KE

F1	99.03.03	ADD DEO 914.3	
F2	01.03.28	$\phi 0.93$ WAS $\phi 0.75$	RF
F3	02-01-23	CLASSIFY CORE DIMS	RF







ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

DESIGN		DRAWN BY		DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	<i>KE</i>	APPROVED	<i>KE</i>	DRAWING NO.	REV. F
DATE	<i>MM</i>		<i>JA</i>	D2432	SHEET 1 OF 2
98.05.12				TITLE	SCALE
				BEARPAW	1:6
A		95.10.31		NEW ISSUE	
B		96.01.24		RE-DESIGN	
C		96.03.26		CHANGE BORE AND C'BORE DEPTH	
D		96.06.04		MOVE SLOT	
E		97.02.27		CHANGE C'BORE DEPTH, BORE RADIUS	
F		98.05.12		CHANGE C'BORE, ADD B AND F P/N	

EFFECTIVE DEOS

9143

260 (TYP) 
~~75 C-BORE Ø 0.13 C-BORE~~
~~5 DEEP FROM TOP (MIN.)~~
~~0 DEEP FROM BOTTOM~~
~~(AVE 0.300 MIN.)~~ 
AVE G. 650 MIN.) 
375 

FBI

0.950 (REF)

D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

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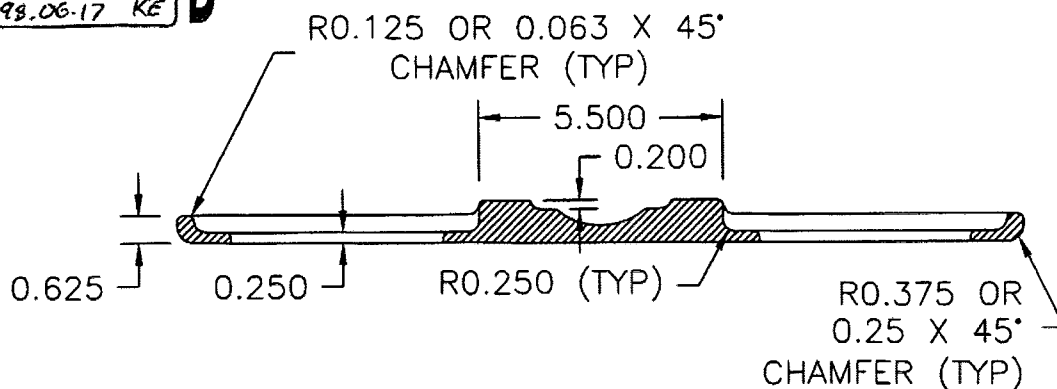
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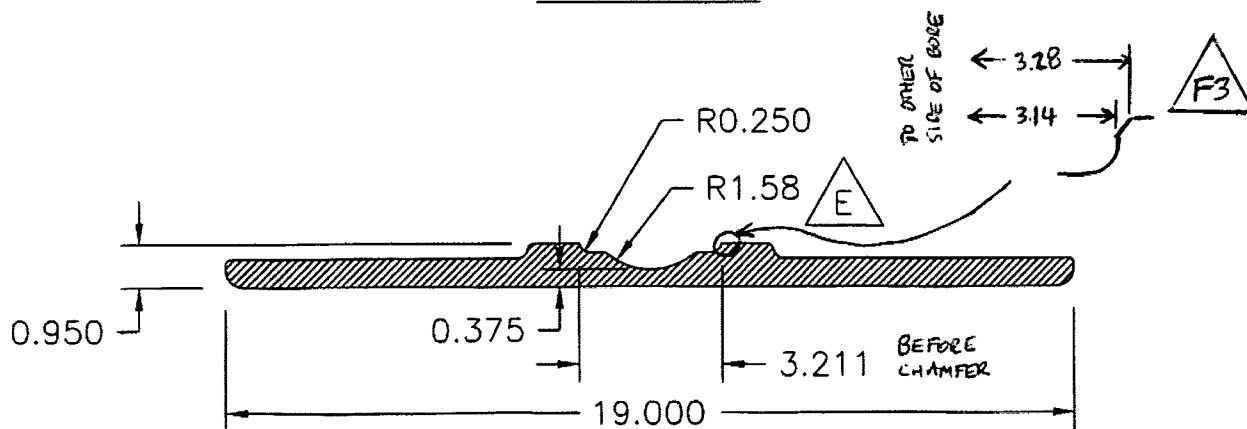


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW		SCALE 1:4

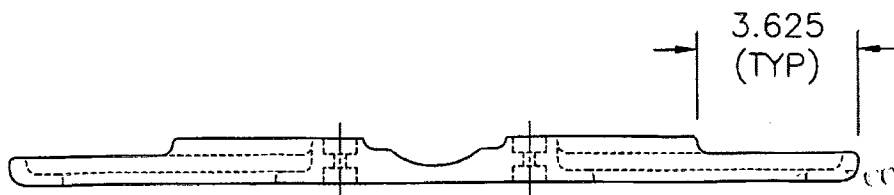
RELEASED
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

COPY
K INTO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK OF
NO. 45847.